



Dart Aerospace Ltd.
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D4146-1
Job Sheet 200072



Part No: D4146-1

Job Qty: 20 pcs

Part Name: Fitting



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/6/19

Job Tracking No:

Due Date: 9/23/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 10-10-05 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	20 pcs	9/23/19	9/23/19	1.00	8.00	Doosan, -1		
120	QC 8	20 pcs	9/23/19	9/23/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		DAS 74 9-89
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Packaging 3-1 - Stock - B4B	20 pcs	9/23/19	9/23/19	0.00	0.00	Packaging 3 - 1 - B4B		DAS 74 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		



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Container No: S218184



Part: D4146-1

Job No: 200072

Serial No/Batch: S218184

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/20/19

				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - SA	20 pcs	9/23/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Dag
21
8-88

OCT 02 2019

Part Op 100 - (Doosan Lathe)
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R1.000	303 Round Bar 1.00	3.3320 ft (.1666 ea)	100-Doosan - 1	5178000

44"
120"

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M303R1.000	3	33	0

9/3/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fitting	0.290Inches + 0.006 - 0.001	0.296 0.289		
2	Fitting	0.810Inches ± 0.010	0.820 0.800		.2925 Diameter
3	Fitting	0.550Inches ± 0.010	0.560 0.540		.8105 Diameter
4	Fitting	0.470Inches ± 0.010	0.480 0.460		.558 Diameter
5	Fitting	0.330Inches ± 0.010	0.340 0.320		.470 Diameter
6	Fitting	0.063Inches ± 0.010	0.073 0.053		.34 Diameter
7	Fitting	1.790Inches ± 0.030	1.820 1.760		.064
8	Fitting	1.700Inches ± 0.030	1.730 1.670		1.792
9	Fitting	1.590Inches ± 0.030	1.620 1.560		1.704
10	Fitting	1.190Inches ± 0.030	1.220 1.160		1.586
11	Fitting	0.840Inches ± 0.030	0.870 0.810		1.193
12	Fitting	0.810Inches ± 0.030	0.840 0.780		.844
13	Fitting	0.500Inches ± 0.030	0.530 0.470		.8105
14	Fitting	0.539Inches ± 0.010	0.549 0.529		.498 Diameter
					.535

Plex 9/6/19 11:13 AM Dart.lajeunesse.marie

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐		MRB (Q51042) ☐ ☐ ☐ ☐ ☐	
Date : _____		Sequence #: _____		QTY Affected : _____			
Description Work Order Deviation		Disposition		Completed By			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐			
		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
Lead hand / Supervisor		QC / QA Coordinator					